



# BEST AVAILABLE COPY

Replacement Sheet 1  
Serial No.: 10/828,751  
Title: System and Method for Plant Management  
Inventors: Price, et al.

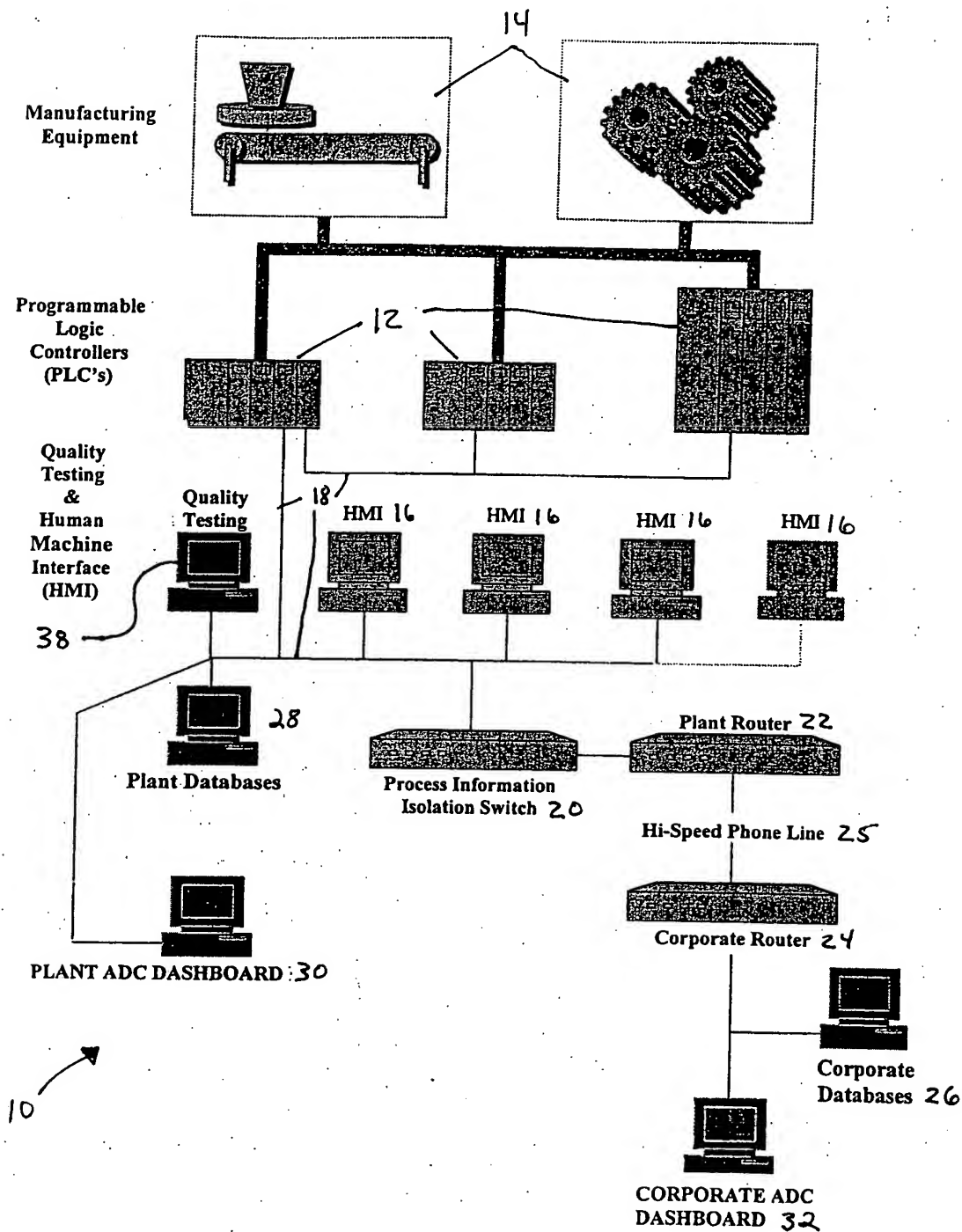


Fig. 1

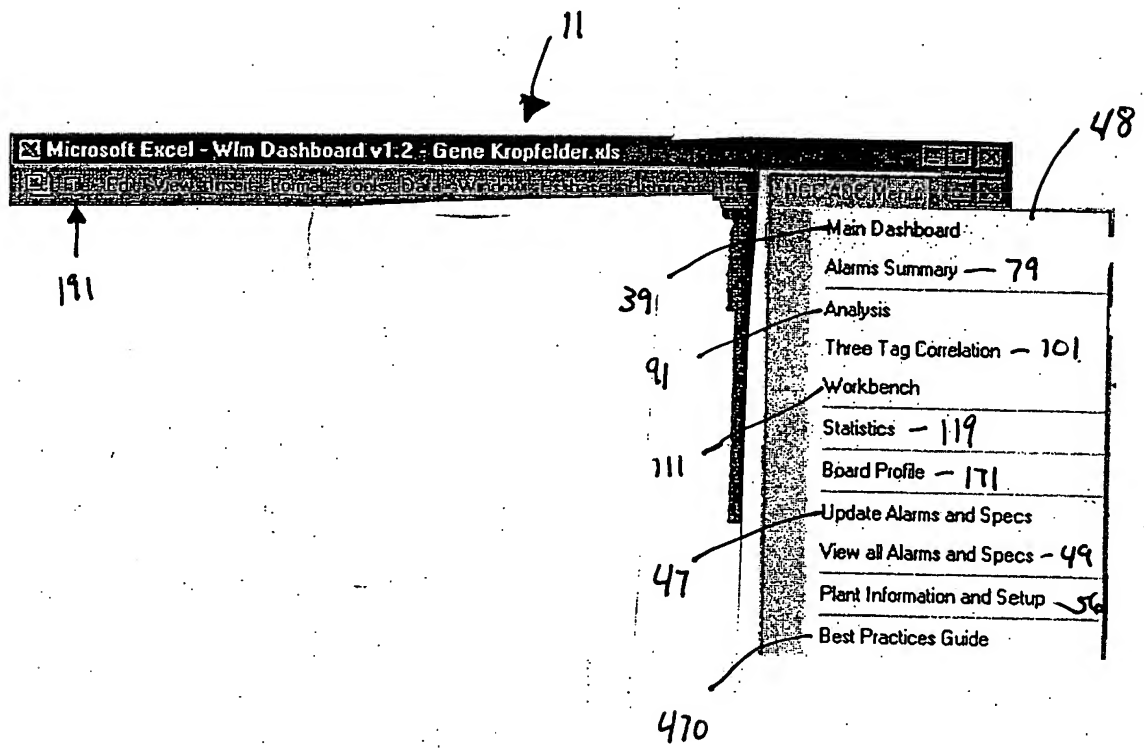


Figure 2a

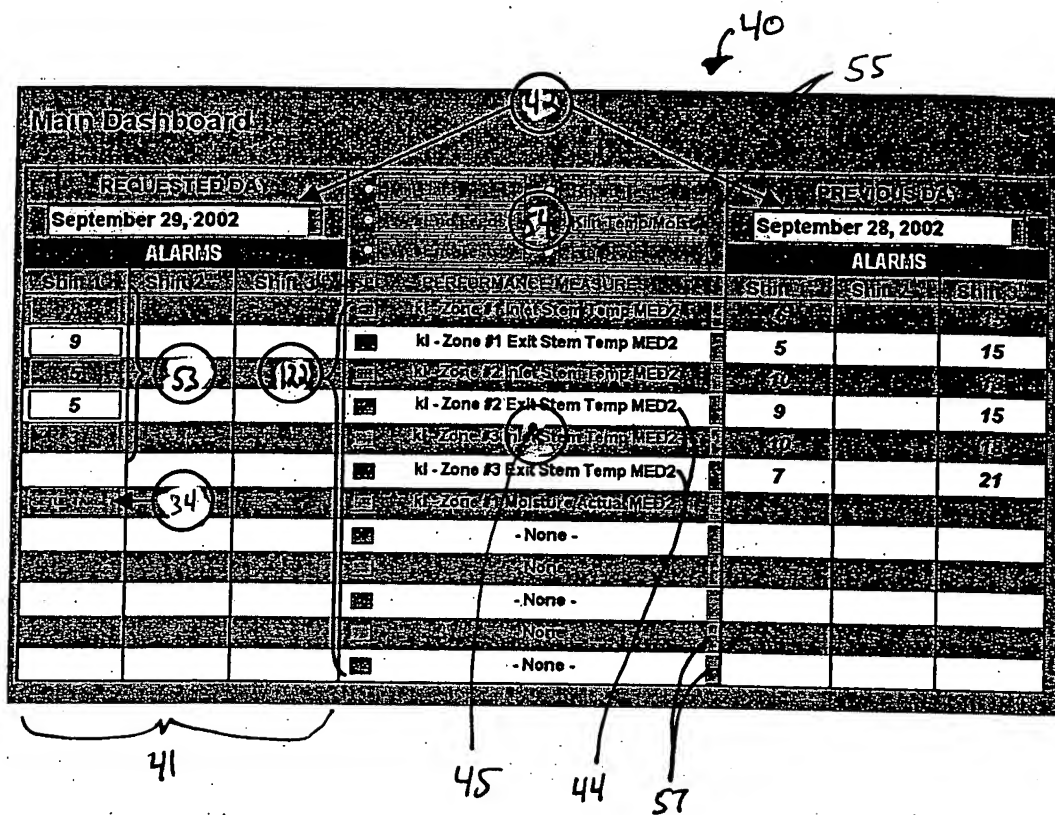


Fig. 2b

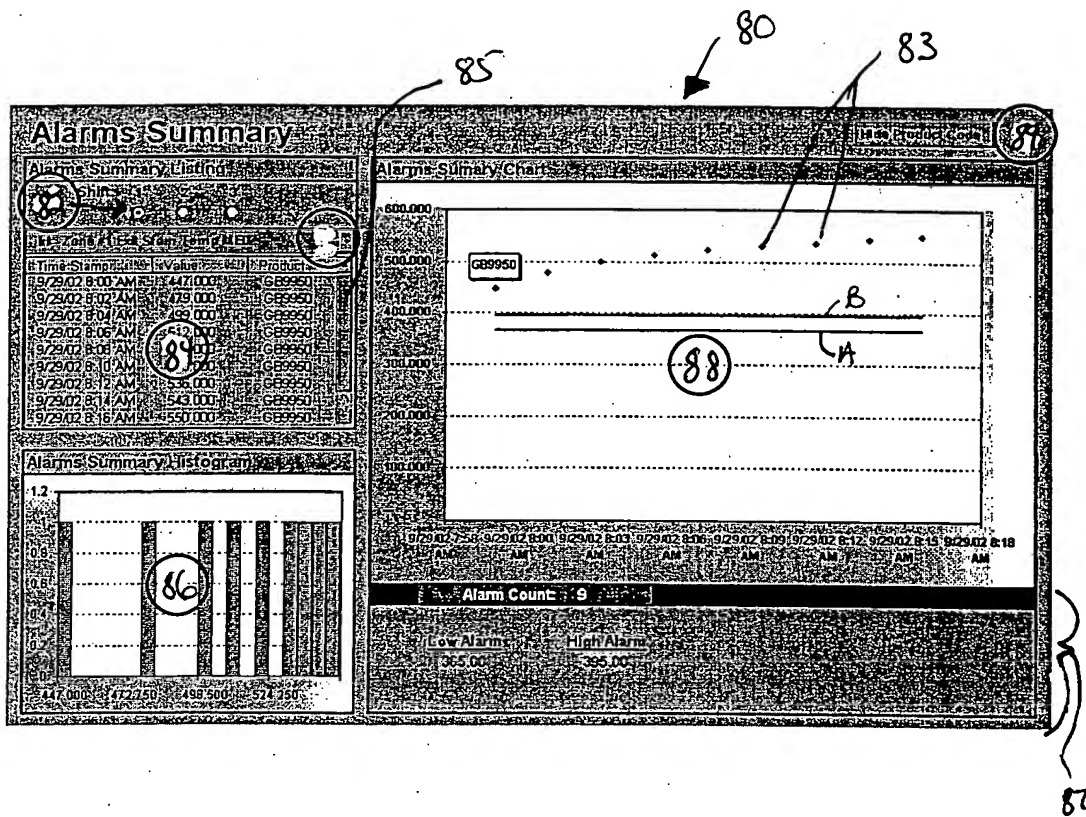


Fig. 3

Replacement Sheet 5  
 Serial No.: 10/828,751  
 Title: System and Method for Plant Management  
 Inventors: Price, et al.

435

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436

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Update Alarms and Specifications

UPDATE

CANCEL

Select From: 54

Select Measure At: 50

ml - Calcine #6 Outlet Temp Actual

PLC Value	All	1	2	3	4	5	6	7	8	9	10	11	12	13
Product Description	All	GB4080	GB0019	GB6270	GB0116	GB2280	GB5926	GB6793	GB6601	GB6058	GB9950	GB1280	GB1310	
Product Code	All	GB4080	GB0019	GB6270	GB0116	GB2280	GB5926	GB6793	GB6601	GB6058	GB9950	GB1280	GB1310	
High Alarm	370	370	370	370	370	370	370	370	370	370	370	370	370	
Low Alarm	330	330	330	330	330	330	330	330	330	330	330	330	330	
Upper Spec Limit	0	0	0	0	0	0	0	0	0	0	0	0	0	
Lower Spec Limit	0	0	0	0	0	0	0	0	0	0	0	0	0	

Fig. 4a

Replacement Sheet 6  
Serial No.: 10/828,751  
Title: System and Method for Plant Management  
Inventors: Price, et al.

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Microsoft Excel - Win Dashboard v1.2 - Gene Krapfeldt

Alarms and Warnings Specification

Row for Last Tag

PLC Value	A1	1	2	3	4	5	6	7	8	9	10	11	12	13	14
Product Description	A1	3/4" TE	1/2" TE	1/2" KX	1/2" FSO	1/2" MR	1/2" KX FS	HS CELL	STA SMO	SHEATH	5/8" FS	5/8" MR FS	5/8" KX FS	5/8" FS	5/8" FS
Product Code	A1	GB9990	GB4090	GB5920	GB6793	GB3780	GB1242	GB0019	GB6270	GB9000	GB9950	GB1400	GB1050	GB9466	
win BL Line Speed Actual		190	190	190	190	190	190	190	190	190	190	190	190	190	190
High Alarm		140	140	140	140	140	140	140	140	140	140	140	140	140	140
Lower Spec Limit															
Upper Spec Limit															
Retrieval Interval															
win VE Soap Actual		0.8	0.8	0.8	0.8	0.8	0.8	0.8	0.8	0.8	0.8	0.8	0.8	0.8	0.8
High Alarm		0.45	0.45	0.45	0.45	0.45	0.45	0.45	0.45	0.45	0.45	0.45	0.45	0.45	0.45
Lower Spec Limit															
Upper Spec Limit															
Retrieval Interval															
win VE Stucco Temp		220	220	220	220	220	220	220	220	220	220	220	220	220	220
High Alarm		190	190	190	190	190	190	190	190	190	190	190	190	190	190
Lower Spec Limit															
Upper Spec Limit															
Retrieval Interval															
win KF Rammer Weight Actual		2600	2600	2600	2600	2600	2600	2600	2600	2600	2600	2600	2600	2600	2600
High Alarm		2300	2300	2300	2300	2300	2300	2300	2300	2300	2300	2300	2300	2300	2300
Lower Spec Limit															
Upper Spec Limit															
Retrieval Interval															
win VE Gauging Water Actual		620	620	620	620	620	620	620	620	620	620	620	620	620	620
High Alarm		400	400	400	400	400	400	400	400	400	400	400	400	400	400
Lower Spec Limit															
Upper Spec Limit															
Retrieval Interval															
win DE Moisture Average		18.5	18.5	18.5	18.5	18.5	18.5	18.5	18.5	18.5	18.5	18.5	18.5	18.5	18.5
High Alarm		12.5	12.5	12.5	12.5	12.5	12.5	12.5	12.5	12.5	12.5	12.5	12.5	12.5	12.5
Lower Spec Limit															
Upper Spec Limit															
Retrieval Interval															
win RD Pan Feeder Rate Actual		55	55	55	55	55	55	55	55	55	55	55	55	55	55
High Alarm		1	1	1	1	1	1	1	1	1	1	1	1	1	1
Lower Spec Limit															
Upper Spec Limit															
Retrieval Interval															
win RD Moisture Actual		77	77	77	77	77	77	77	77	77	77	77	77	77	77
High Alarm		72	72	72	72	72	72	72	72	72	72	72	72	72	72
Lower Spec Limit															
Upper Spec Limit															
Retrieval Interval															

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Fig. 46

Replacement Sheet 7  
 Serial No.: 10/828,751  
 Title: System and Method for Plant Management  
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Product Information				Shift Information	
PLC Value	Product Code	Description	Width (Inches)	Shift	Start/End
0	NONE	NO PRODUCT RUNNING	NONE	1 <sup>st</sup> SHIFT	8:00 AM - 4:00 PM
1	GB0080	1/2" REG TE	48	2 <sup>nd</sup> SHIFT	4:00 PM - 12:00 AM
2	GB0019	1/2" HS TE	48	3 <sup>rd</sup> SHIFT	12:00 AM - 8:00 AM
3	GB0270	1/2" SS TE (Sta-Smooth)	48		
4	GB0116	1/2" SS HS (Sta-Smooth)	48		
5	GB2280	1/2" KK TE	48		
6	GB5926	1/2" DB (DuraBase)	48		
7	GB6733	1/2" FSC TE	48		
8	GB6601	1/2" FSC SS (Sta-Smooth)	48		
9	GB6068	1/2" FSC KK	48		
10	GB9950	5/8" FS TE	48		
11	GB1280	5/8" FS SS	48		
12	GB1310	5/8" FS SS	48		
13					
14					
15					
16					
17					
18					
19					
20					
21					
22					
23					
24					

70

66

64

68

76

Plant Information	
Line Length (Mixer to Knife) - Feet	595
Web Transfer Length - Feet	30
Kiln Length - Feet	413
Number of Deck in Mill	3
Kiln Zone 1 Length - Feet	121
Kiln Zone 2 Length - Feet	107
Kiln Zone 3 Length - Feet	205
Kiln Zone 4 Length - Feet	79

34

37

36

Fig. 5

Replacement Sheet 8  
 Serial No.: 10/828,751  
 Title: System and Method for Plant Management  
 Inventors: Price, et al.

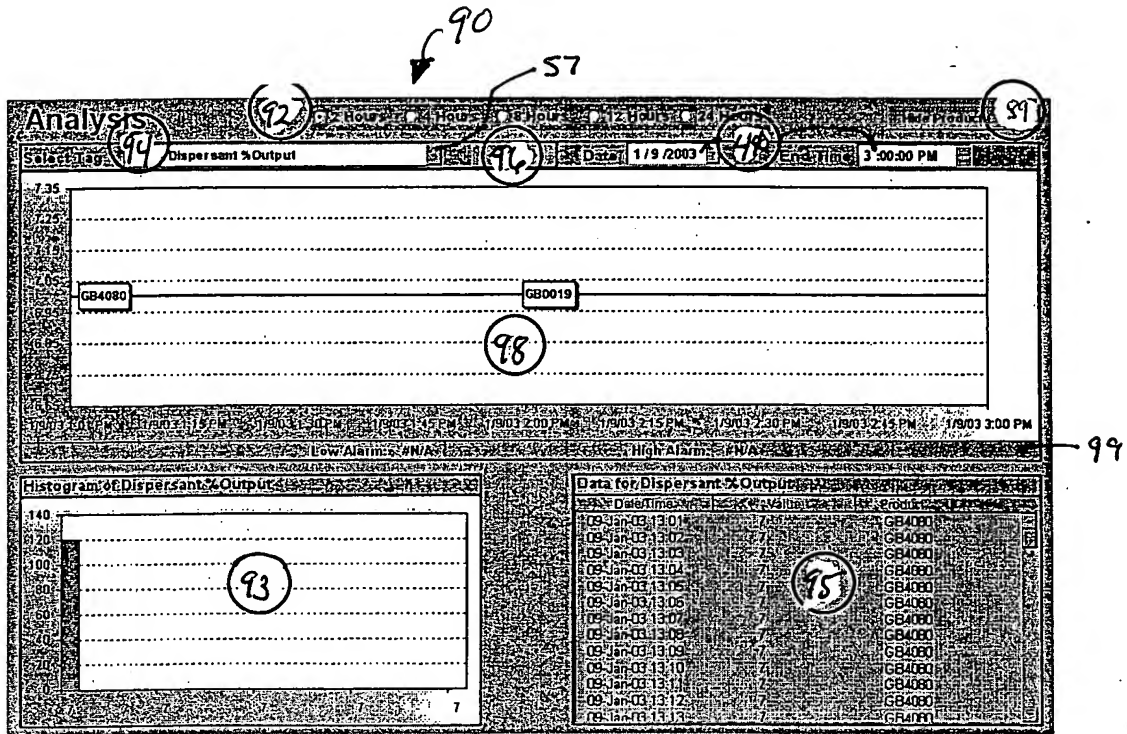


Fig. 6



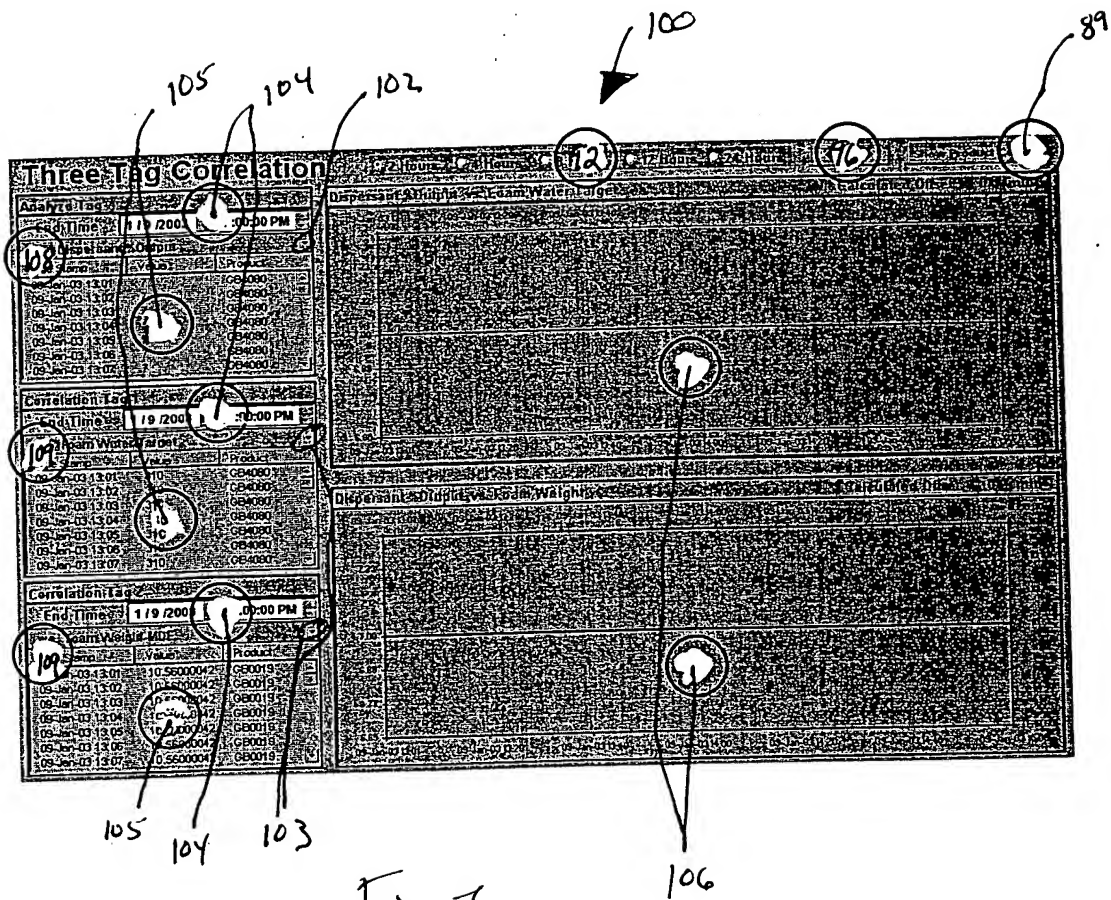


Fig. 7

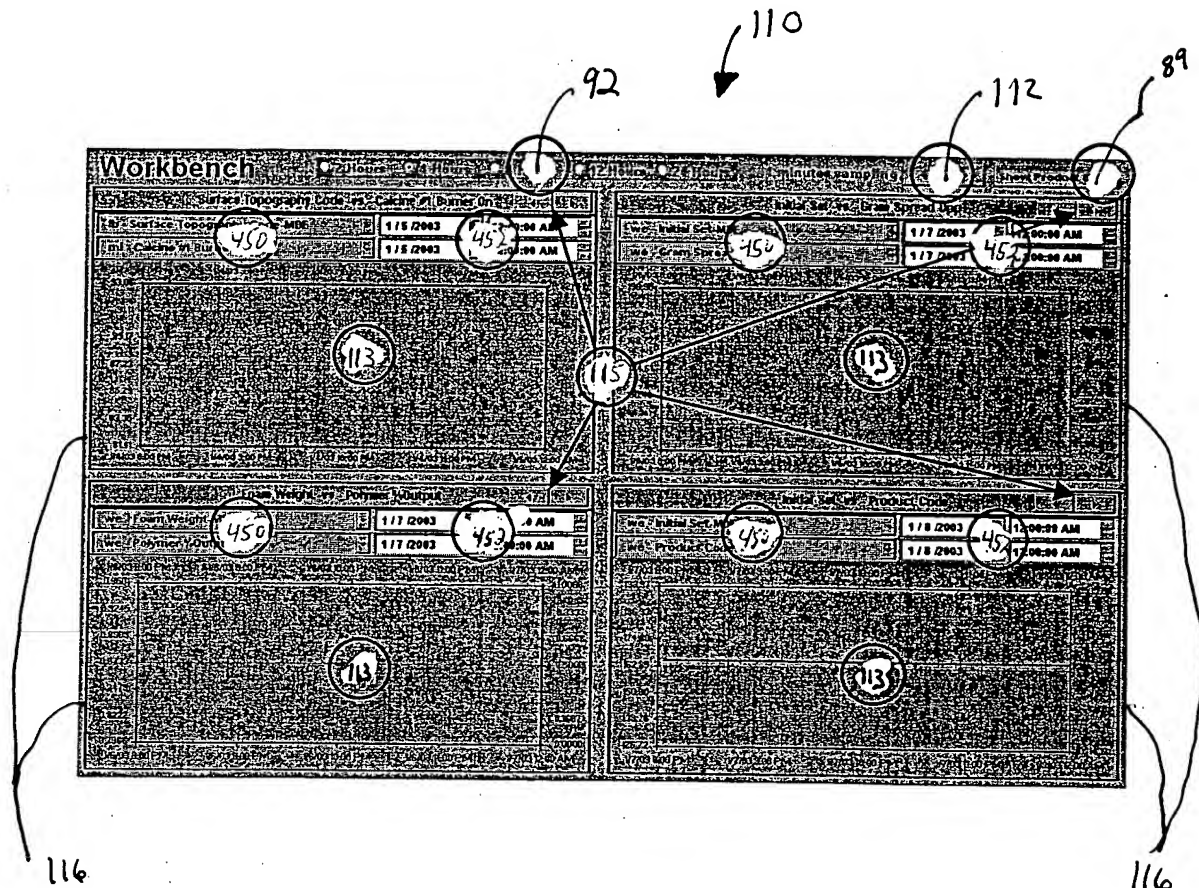


Fig. 8

Replacement Sheet 11  
 Serial No.: 10/828,751  
 Title: System and Method for Plant Management  
 Inventors: Price, et al.

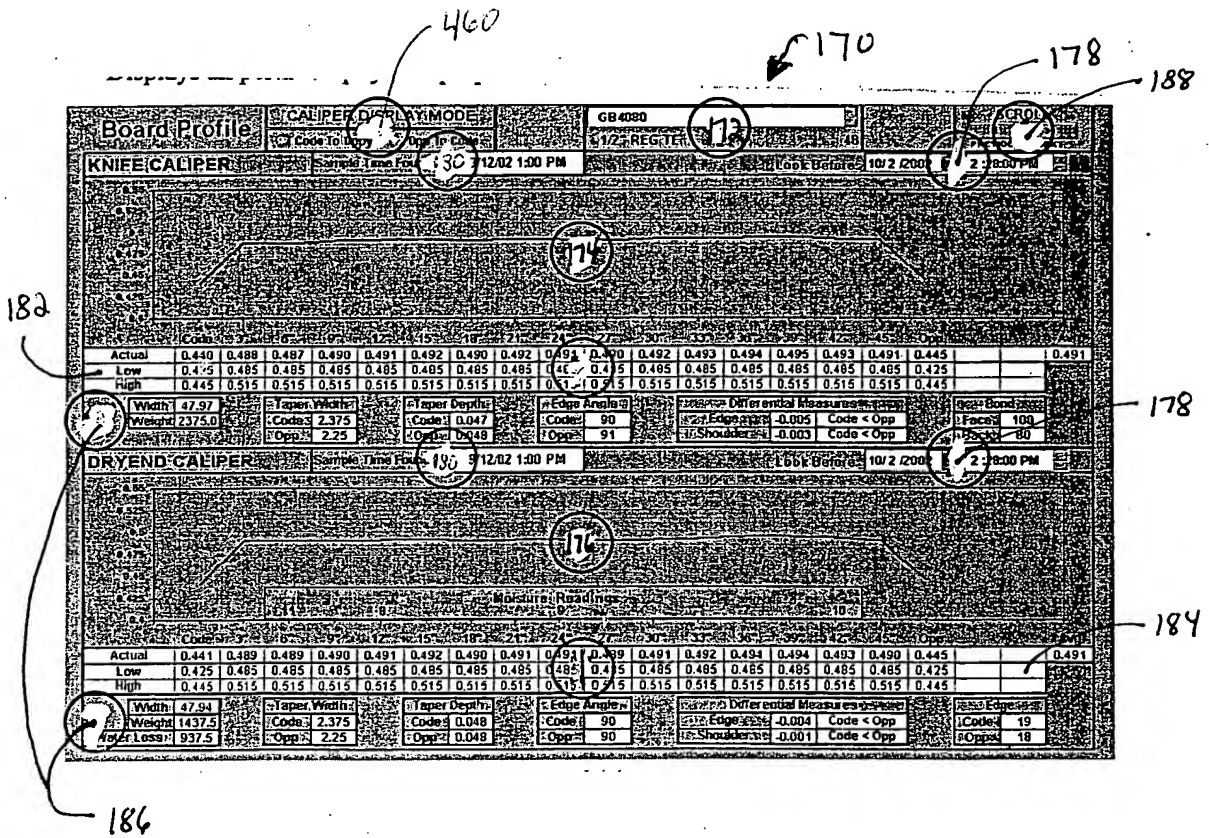


Fig. 9

Replacement Sheet 12  
 Serial No.: 10/828,751  
 Title: System and Method for Plant Management  
 Inventors: Price, et al.

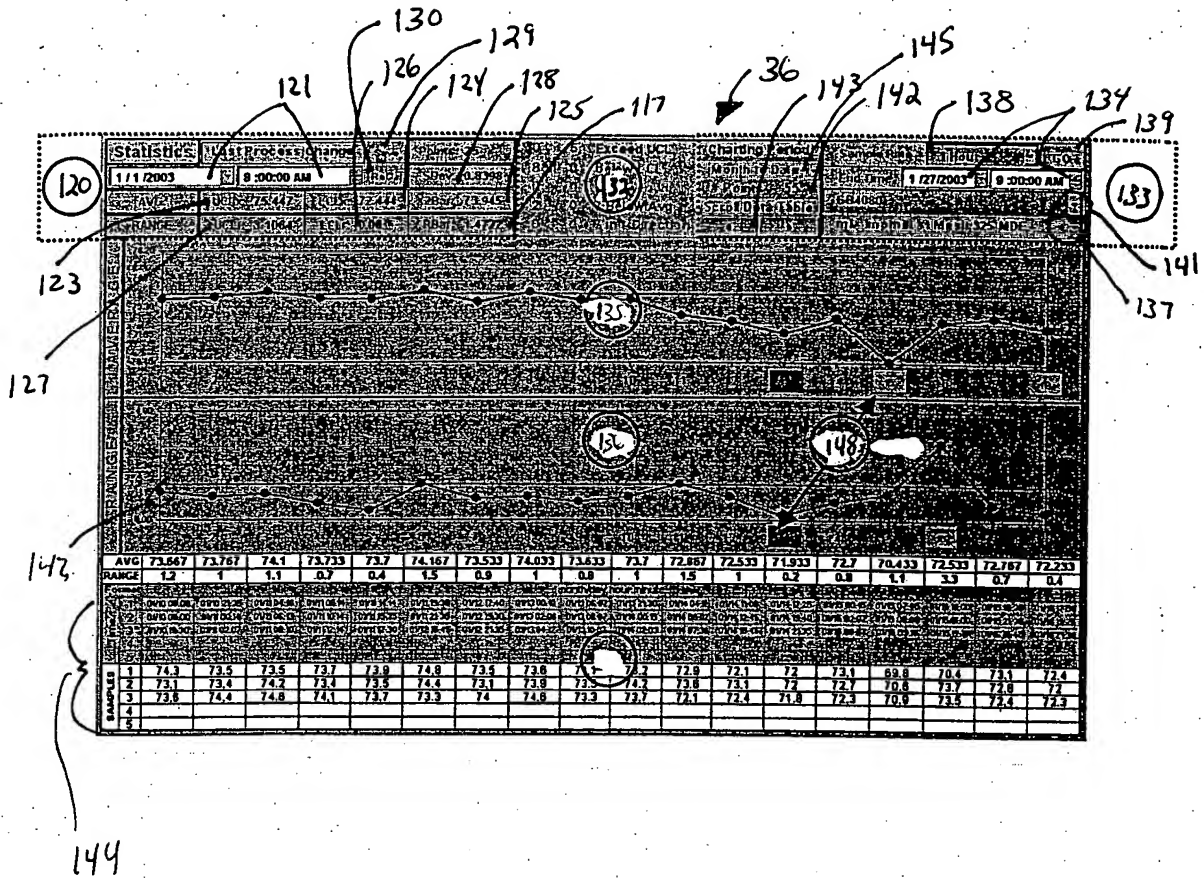


Fig. 10

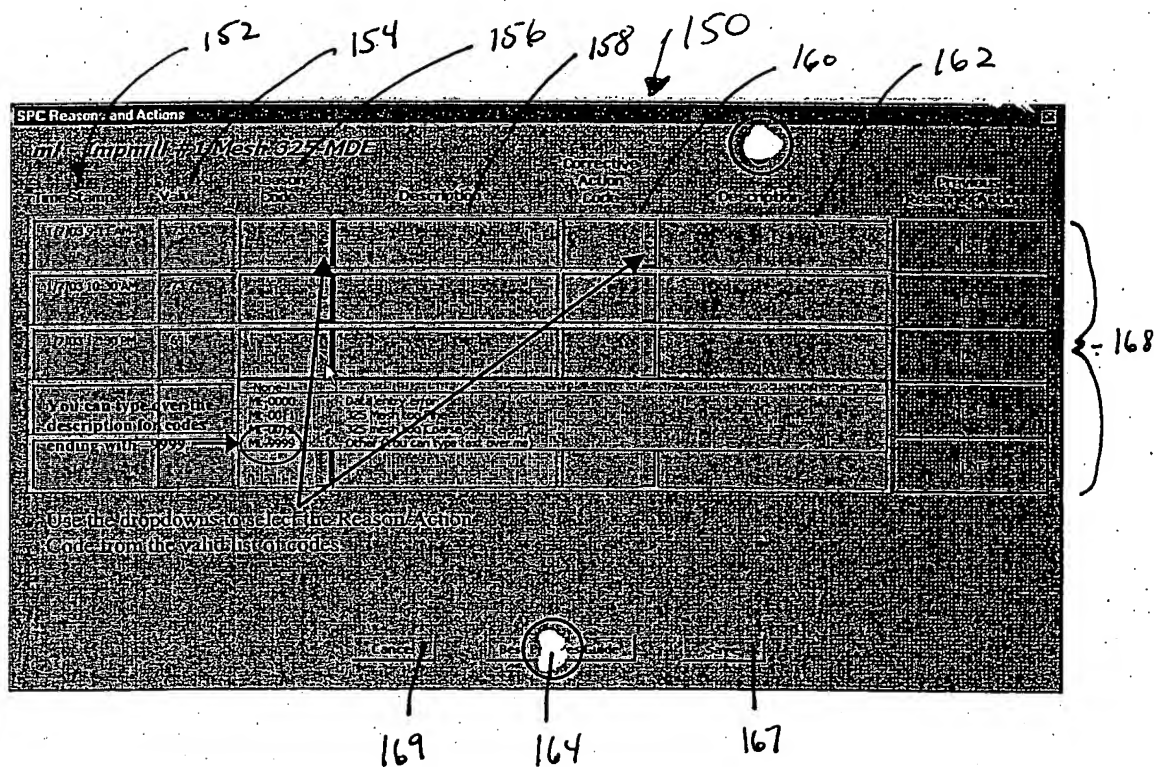


Fig. 11a



Fig. 116

The goal of this SOP is to produce stucco that is calcined below theoretical with as few adjustments as possible.

BEST PRACTICE/S.O.P.

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↓

1. Combined water of stucco exceeds the upper limit.

Make sure the grinds are in the reasonable limits.

(Course grounds will cause the moistures to go up)

Examine the history of previous moisture's.

(2 samples in a row high or most of the samples were high)

Examine the purity.

(If the purity went up quite a bit, the moisture's will get higher)

If grinds are out of the control limits, they need to be lined out before any adjustments are made to the calcidyne's.

If grinds are in the control limits and purity is stable and sample still exceeds the upper limits then an adjustment to the calcidyne needs to be made.

When the purity goes up, it may take some time for the calcidyne's to adjust, no need to make adjustments right away. Run a couple of samples and see if they will adjust by themselves. If not make an adjustment.

2. Combined water of stucco is less than the lower limit

Make sure the grinds are in the reasonable limits.

(Fine grinds will cause the moistures to go down)

Examine the history of previous moisture's.

(2 samples in a row low or most of the samples were low)

Examine the purity.

(If the purity went down quite a bit, the moisture's will get lower).

If grinds are out of the control limits, they need to be lined out before any adjustments are made to the calcidyne's.

If grinds are in the control limits and purity is stable and sample still exceeds the lower limits then an adjustment to the calcidyne needs to be made.



192

**Quality Report Login Screen**

**Open File** 194

**Enter Password**  **Enter Password** 189

Required to Change Plant Server

Required to Activate the Open File Button, if a Corporate User

**Select Plant**  195

**Select Server**  197

Select Plant Only if you are at the plant

Select Corporate only if you are located in Charlotte, or you need to access a plant server other than your own

**The Selected Server Is**  
 199

Fig. 13



193

## MONTHLY BOARD QUALITY REPORT

**Select Plant and Date For Report**

Selected Plant: 185

Select Month & Year: 2002 1968 December

Start Date: 12/1/2002

End Date: 12/31/2002

198

206

**Retrieve Data**

Data must be retrieved before you view Product Details or Reports

**Setup**

Review and Update product information

**Select Products To Include In This Report**

Product 1: 12" HS CEILING

Product 2: 12" MR

Product 3: 12" TE

Product 4: 12" FSG

Product 5: 5/8" FS

210

**View Product Detail**

Product 1 Detail

Product 2 Detail

Product 3 Detail

Product 4 Detail

Product 5 Detail

213

**View / Print Reports**

Monthly Board Report

Monthly Board Weight Report

Monthly Mil Report

Server In Use: 199 HQADC

197

Selected Server: Corporate

187

201

215

Fig. 14

**Replacement Sheet 18**  
**Serial No.: 10/828,751**  
**Title: System and Method for Plant Management**  
**Inventors: Price, et al.**

**MONTHLY BOARD QUALITY REPORT**

200

PRODUCT CODE AND DESCRIPTION	GB4080 401 1/2 REG TE	GB9950 401 5/8 FS TE	GB2280 901 1/2 KK TE	GB0019 401 1/2 HS TE	GB0116 401 1/2 SS HS (Sta Smooth)
Lab 401	NAIL PULL lbs of force				
Number of samples	75	22	1	9	4
Specification ( Min )	80.0	90.0	80.0	80.0	80.0
3-Month Rolling Average	71.4	84.8	82.1	70.6	70.9
Standard Deviation	2.722	4.458		2.985	3.081
Year-to-Date Average	71.4	84.8	82.1	70.6	70.9
Prior Year Average	74.886	89.838	85.750	77.067	76.100
Cpk	-1.049	-0.391		-1.046	-0.990
Est. Defects Per 1,000 Units	> 500	> 500		> 500	> 500
Cp	-1.049	-0.391		-1.046	-0.990
Lab	CORE HARDNESS lbs of force				
Number of samples	68	21	1	9	4
Specification ( Min )	15.0	15.0	15.0	15.0	15.0
3-Month Rolling Average	17.1	23.0	19.3	17.1	16.3
Standard Deviation	1.366	1.750		1.054	0.831
Year-to-Date Average	17.1	23.0	19.3	17.1	16.3
Prior Year Average	18.276	23.056	17.333	18.389	16.889
Cpk	0.518	1.514		0.668	0.535
Est. Defects Per 1,000 Units	80	< 1		40	80
Cp	0.518	1.514		0.668	0.535
Lab	EDGE HARDNESS CODE lbs of force				
Number of samples	67	21	1	8	4
Specification ( Min )	15.0	15.0	15.0	15.0	15.0
3-Month Rolling Average	56.1	72.4	64.3	56.5	51.7
Standard Deviation	4.725	9.285		6.644	7.193
Year-to-Date Average	56.1	72.4	64.3	56.5	51.7
Prior Year Average	42.430	64.194	55.000	43.846	47.000
Cpk	2.900	2.061		2.080	1.703
Est. Defects Per 1,000 Units	< 1	< 1		< 1	< 1
Cp	2.900	2.061		2.080	1.703
Lab	EDGE HARDNESS OPP CODE lbs of force				
Number of samples	66	21	1	8	4
Specification ( Min )	15.0	15.0	15.0	15.0	15.0
3-Month Rolling Average	62.1	75.0	79.3	57.7	62.7
Standard Deviation	5.351	7.700		4.366	0.837
Year-to-Date Average	62.1	75.0	79.3	57.7	62.7
Prior Year Average	49.159	60.030	62.222	46.282	47.000
Cpk	2.934	2.599		3.261	19.016
Est. Defects Per 1,000 Units	< 1	< 1		< 1	< 1
Cp	2.934	2.599		3.261	19.016
Lab	END HARDNESS lbs of force				
Number of samples	69	21	1	9	4
Specification ( Min )	15.0	15.0	15.0	15.0	15.0
3-Month Rolling Average	16.1	22.2	20.3	16.4	15.2
Standard Deviation	1.385	1.798		0.961	0.638
Year-to-Date Average	16.1	22.2	20.3	16.4	15.2
Prior Year Average	17.829	22.528	18.000	18.028	16.889
Cpk	0.255	1.336		0.488	0.087
Est. Defects Per 1,000 Units	300	< 1		120	> 500
Cp	0.255	1.336		0.488	0.087

Fig. 15

431

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**Return**

**Monthly Board Weight Report**

PLANT : Wilmington MONTH : February 2003

**Save As File...**

430

1/2" SHEATHING Board	MONTHLY WEIGHT DATA		
	AVG WEIGHT	STD DEV	# OF SAMPLES
December 2002	1719	9	2
January 2003	1713	16	6
February 2003			
March 2003			
April 2003			
May 2003			
June 2003			
July 2003			
August 2003			
September 2003			
October 2003			
November 2003			
December 2003			
YTD AVERAGE	1713	16	6

Fig. 16

Replacement Sheet 20  
Serial No.: 10/828,751  
Title: System and Method for Plant Management  
Inventors: Price, et al.

Product Data

PLC Value	Description	Product Code	Width	STD Speed	STD Dry Weight	STD Water Loss	STD - 2-Hr Humidified Bond	STD - 20-Hr Humidified Bond	Go Live Date
0	NO PRODUCT RUNNING	NCNE	NA	NA	NA	NA	NA	NA	6/1/02 12:00 AM
1	3/8" TE	GB3930	48"						
405	1/2" TE 406	GB5620	48"			409			
1	1/2" KK	GB5620	48"						
4	1/2" FSG	GB6793	48"						
5	1/2" MR	GB3760	48"						
6	1/2" KK FS	GB1242	48"						
7	1/2" HS CEILING	GB0019	48"						
8	1/2" SS (STA SMOOTH)	GB6270	48"						
9	1/2" SHEATHING	GB8000	48"						
10	5/8" FS	GB9950	48"						
11	5/8" MR FS	GB1400	48"						
12	5/8" KK FS	GB1050	48"						
13	5/8" FS JS	GB9466	48"						
14									
15									
16									
17									
18									
19									
20									
21									
22									
23									

Return

Fig. 17

**Title: System and Method for Plant Management**  
**Inventors: Price, et al.**

Fig. 18a.

**Replacement Sheet 22**  
**Serial No.: 10/828,751**  
**Title: System and Method for Plant Management**  
**Inventors: Price, et al.**

	Machine Speed	Dry Weight	Wet Weight	Water Loss	Board Width	Taper Depth				Core Hardness	Edge Hardness		End Hardness	d Deflection	Face Up MD	Face Down	Transverse
						Code	Opp Code	Caliper	Nail Pull		Code	Opp Code					
<b>February 2002</b>																	
3-Month Rolling Avg	180.8	2511	800	47.997	0.057	0.058	0.490	77.5	21.8	28.8			19.0	0.128	48	50	
Average	2931	845	54	593	587	588	593	49	3	3	0	3	3	28	49	49	
LSL				47.2932	0.050	0.050	0.485	80	15.0	15.0	15.0	15.0	15.0	15.0	40	40	
USL				48	0.090	0.090	0.515										
Std Dev	3.484	55.309	45.958	33.603	0.018	0.020	0.017	0.004	4.367	1.072	2.411		0.882	0.025	4.442	3.520	
Std Dev / 1.7321	2.000	31.867	26.533	19.400	0.009	0.011	0.010	0.002	2.533	0.619	1.352		0.509	0.014	2.564	2.050	
Coku					0.115	0.948	1.178	3.890									
Cokd					3.230	0.217	0.222	0.828	-0.334	3.652	3.289		2.819	28.368	1.037	1.668	
Cok					0.115	0.217	0.222	0.828	-0.334	3.652	3.289		2.819	28.368	1.037	1.668	
Cp					1.873	0.583	0.698	2.359	-0.334	3.652	3.289		2.819	28.368	1.037	1.668	
<b>3-Month Period Ending</b>																	
January	181.1	1712	2509	798	48.00	0.058	0.058	0.490	77.5	21.8	28.8		19.0	0.128	48	50	
February	180.6	2511	800	48.00	0.057	0.058	0.490	77.5	21.8	28.8			19.0	0.128	48	50	
March	179.9	2517	807	48.00	0.058	0.057	0.491	77.1	21.2	30.2			19.2	0.117	51	51	
April	177.0	2527	835	48.00	0.053	0.057	0.492										
May																	
June																	
July																	
August																	
September																	
October																	
November																	
December																	

Fig. 18b

	Machine Speed	Dry Weight	Wet Weight	Water Loss	Board Width	Taper Depth				Core Hardness	Edge Hardness		End Hardness	d Deflection	Face Up MD	Face Down	Transverse
						Code	Opp Code	Caliper	Nail Pull		Code	Opp Code					
<b>Current Year Info</b>																	
Year-to-date Avg	178.9	1710	2517	807	48.00	0.058	0.057	0.491	77.1	21.2	30.2		19.2	0.117	51	51	
Entire Year Avg	179.9	2517	807	48.00	0.058	0.057	0.491	77.1	21.2	30.2			19.2	0.117	51	51	
December (Last Year)	181.5	2502	791	48.00	0.060	0.058	0.490	77.8	23.0	26.0			18.7	0.133	45	49	
January	180.7	1714	2515	801	48.00	0.058	0.058	0.490	77.1	21.2	30.2		19.2	0.117	51	51	
February	177.0	1692	2527	835	48.00	0.053	0.057	0.492									
<b>Prior Year Info</b>																	
Overwrite Historian Data																	
Enter Year Avg																	
Historian Data																	
Entire Year Avg	178.1	2502	791	48.00	0.060	0.058	0.490	77.8	23.0	26.0			18.7	0.133	45	49	
Year-to-date Avg	178.1	2502	791	48.00	0.060	0.058	0.490	77.8	23.0	26.0			18.7	0.133	45	49	
Enter Year Avg	178.1	2502	791	48.00	0.060	0.058	0.490	77.8	23.0	26.0			18.7	0.133	45	49	

Fig. 18c

Replacement Sheet 23  
 Serial No.: 10/828,751  
 Title: System and Method for Plant Management  
 Inventors: Price, et al.

C:\Documents and Settings\gbccdp\Local Settings\Temporary Internet Files\OLK4\Documentation-Adhoc Reporting Tool\...

252

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250

256

255

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Select Starting Date and Time:  
 February 25, 2003 12:00 AM

Select Plant: Apollo Select Period / Frequency: 1 Day - Every 15 Minutes

Previous Next

Select Measures → WE KF DE KF DE KF DE KF DE KF DE DE DE LB

DATA

Boardline Reading at Down

WE Product Cost KF Product Cost DE Product Cost KF Weight DE Weight KF Width DE Width KF Caliper Average DE Caliper Average DE Caliper Edge Differential DE End Peet Kiln Dry Side Back LB Humidified Solid Face 2 Hour

Average

Standard Deviation

Date / Time

2/25/03 12:00 AM Running 7.000

2/25/03 12:15 AM Running 7.000

2/25/03 12:30 AM Running 7.000

2/25/03 12:45 AM Running 7.000

2/25/03 1:00 AM Running 7.000

2/25/03 1:15 AM Running 7.000

2/25/03 1:30 AM Running 7.000

2/25/03 1:45 AM Running 7.000

2/25/03 2:00 AM Running 7.000

2/25/03 2:15 AM Running 7.000

2/25/03 2:30 AM Running 7.000

2/25/03 2:45 AM Running 7.000

2/25/03 3:00 AM Running 7.000

2/25/03 3:15 AM Running 7.000

2/25/03 3:30 AM Running 7.000

2/25/03 3:45 AM Running 7.000

2/25/03 4:00 AM Running 7.000

2/25/03 4:15 AM Running 7.000

2/25/03 4:30 AM Running 7.000

2/25/03 4:45 AM Running 7.000

2/25/03 5:00 AM Running 7.000

2/25/03 5:15 AM Running 7.000

2/25/03 5:30 AM Running 7.000

2/25/03 5:45 AM Running 7.000

2/25/03 6:00 AM Running 7.000

Fig. 19

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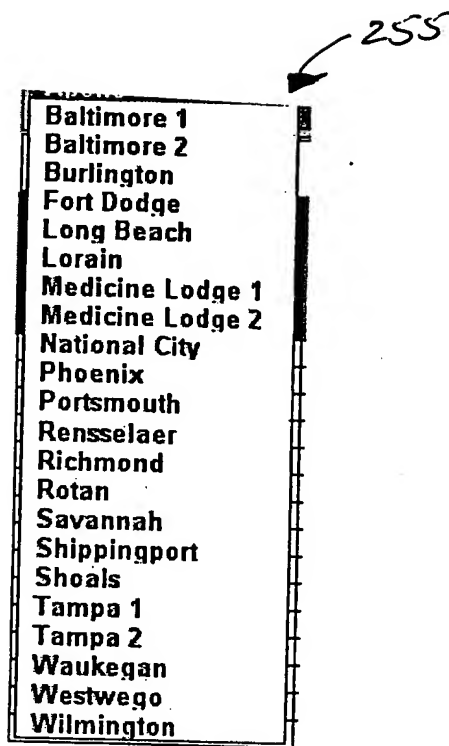
Select Starting Date and Time:		
February 25, 2003		12:00 AM
Sun Mon Tue Wed Thu Fri Sat 26 27 28 29 30 31 1 2 3 4 5 6 7 8 9 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28 1 2 3 4 5 6 7 8 Today: 2/25/2003		
Average		
Standard Deviation		
Date / Time		
2/25/03	12:00 AM	Running
2/25/03	12:15 AM	Running
2/25/03	12:30 AM	Running
2/25/03	12:45 AM	Running
2/25/03	1:00 AM	Running
2/25/03	1:15 AM	Running
2/25/03	1:30 AM	Running
2/25/03	1:45 AM	Running
2/25/03	2:00 AM	Running

253

Fig. 20a



255



Baltimore 1
Baltimore 2
Burlington
Fort Dodge
Long Beach
Lorain
Medicine Lodge 1
Medicine Lodge 2
National City
Phoenix
Portsmouth
Rensselaer
Richmond
Rotan
Savannah
Shippingport
Shoals
Tampa 1
Tampa 2
Waukegan
Westwego
Wilmington

*Fig. 206*

Select Period / Frequency

Fig. 20c

Select Server

257 →

Fig. 20d

Select Measures (Tags)

258 →

Fig. 20e

**Inventors:** Price, et al.

Fig. 21

Fig. 21

**Title:** *System and Method for Plant Management*  
**Inventors:** *Price, et al.*

315

Fig. 22

**Replacement Sheet 29**  
**Serial No.: 10/828,751**  
**Title: System and Method for Plant Management**  
**Inventors: Price, et al.**

National Gypsum  
Gypsum  
CORPORATION

Wet End Manual Data Entry

Miniz

RPM  
SHO  
Line  
1

Select Product
GB4080
312

Product Code
GB4080
40"
1/2" REG TE

Select Date & Time
10/1/2002
10:00:00 AM

Press [UP] or [DOWN]

Press [F1] for Print Page

Cylinder Work Code
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Fig. 23

311  
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313 303

**National Gypsum Company**

**Knife Manual Data Entry**

GB4080 312

SHO 1

GB4080 45° 12" REG TE

10/1/2002 10:00

305 306 314 307 310

308

315

Fig. 24

313

304

LAB MANUAL DATA ENTRY

Plant: SHO 1

Product Code: GB4080

Width: 48"

Height: 12" REG TE

Select Date: 10/1/2002

Select Time: 10:00:00

306

314

307

308

310

315

Fig. 25

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